

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

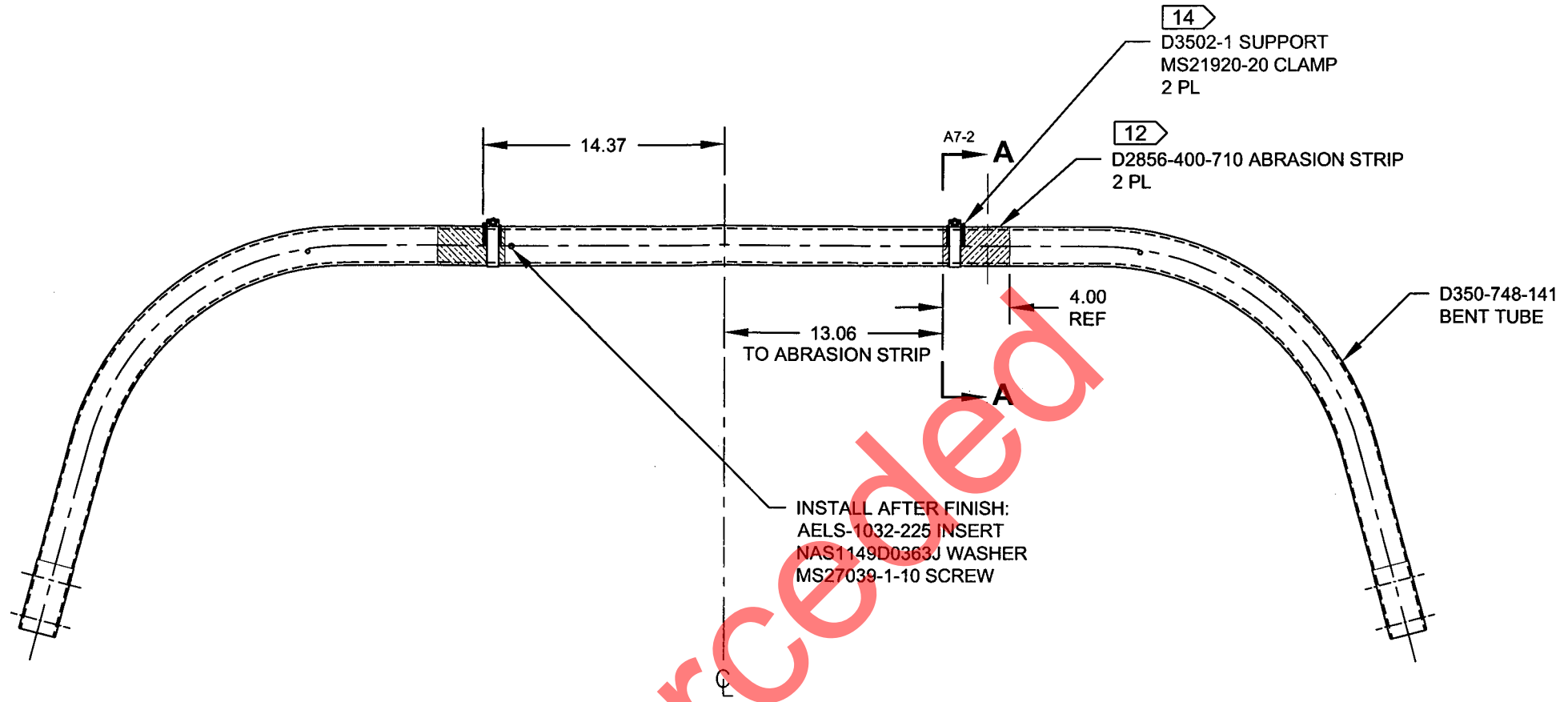
- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

UNDER REVIEW

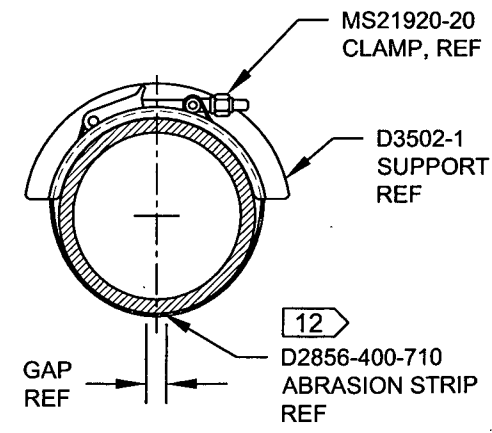
RELEASED
2011-01-18

DEO ATTACHED

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES: UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	qp	DRAWING NO.	REV. F
MFG. APPR.	qp	D350-748-141	SHEET 1 OF 4
APPROVED	qp	TITLE	SCALE
DE APPR.	qp	CROSSTUBE (AS 350/355 HI FWD)	NTS
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**D350-748-141
ASSEMBLY DETAIL**



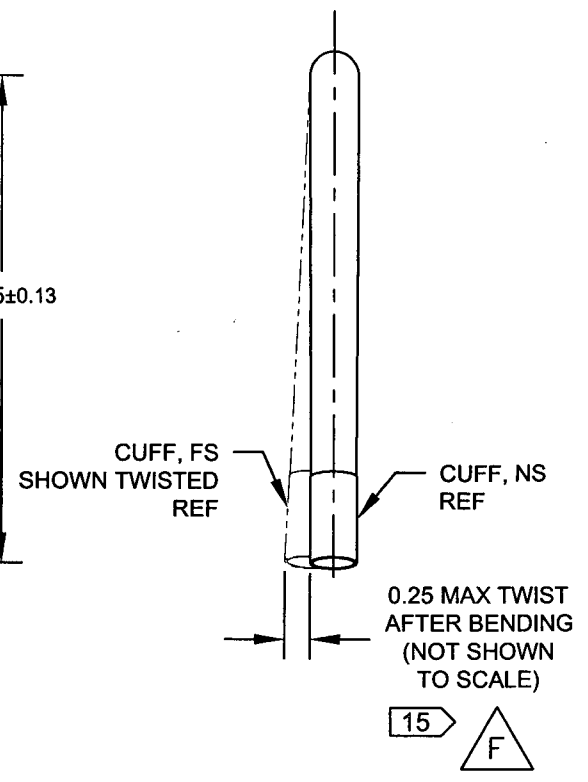
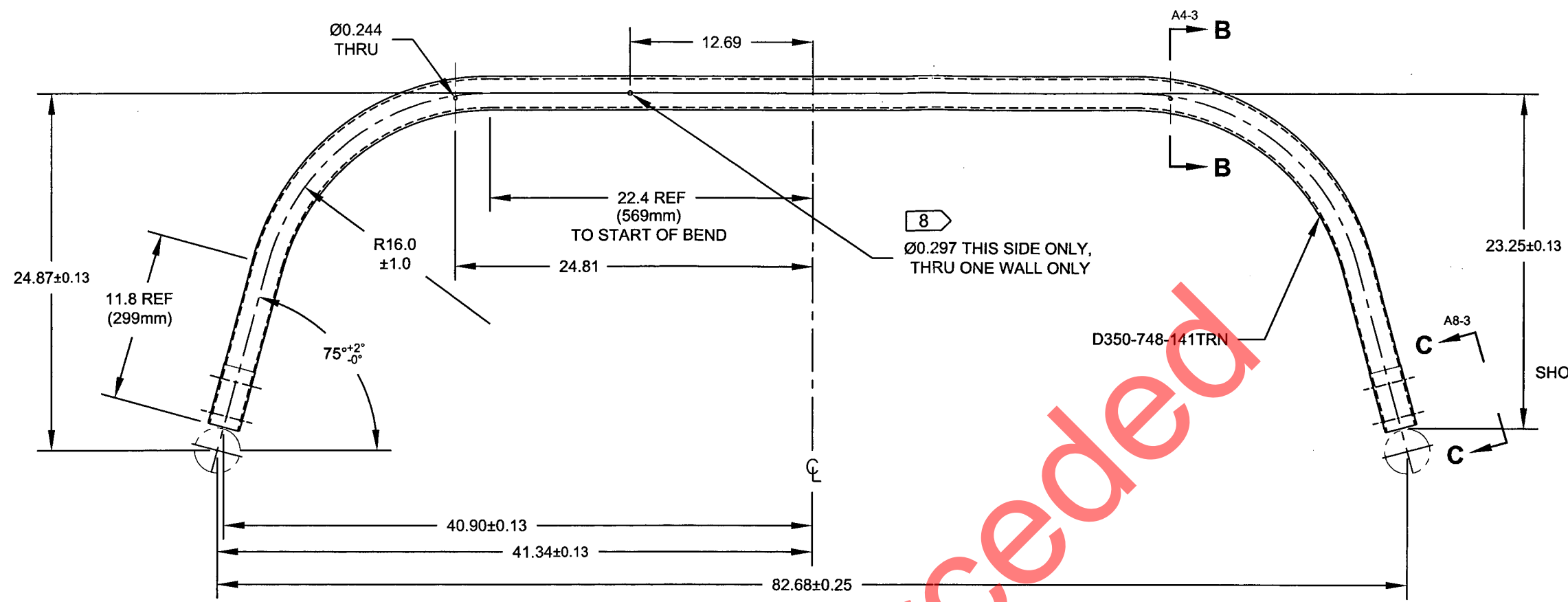
SECTION A-A D4-2
SCALE 4X

UNDER REVIEW
11.07.11

RELEASED
2011-01-18

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	1	DRAWING NO.	REV. F
MFG. APPR.	1	D350-748-141	SHEET 2 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	CROSSTUBE (AS 350/355 HI FWD)	NTS
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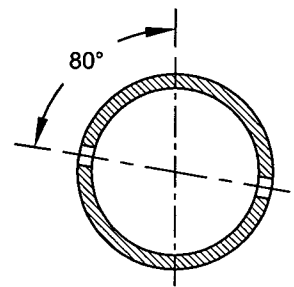
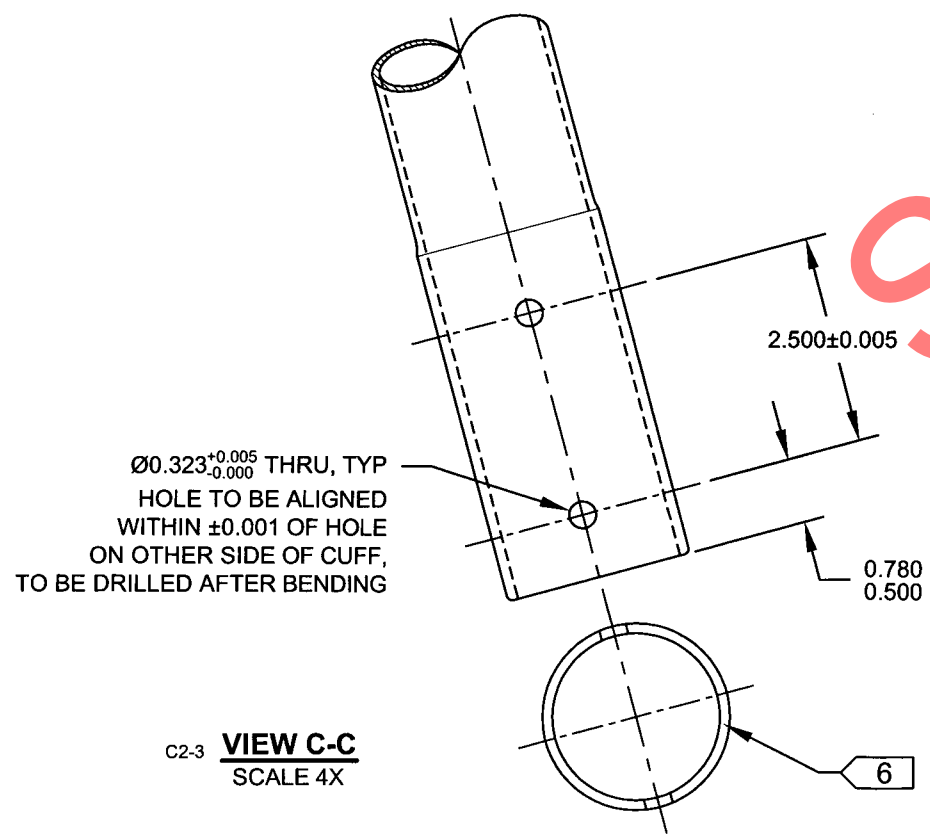
8 7 6 5 4 3 2 1



D350-748-141
BENDING AND DRILLING DETAIL 10

UNDER REVIEW
11.07.12

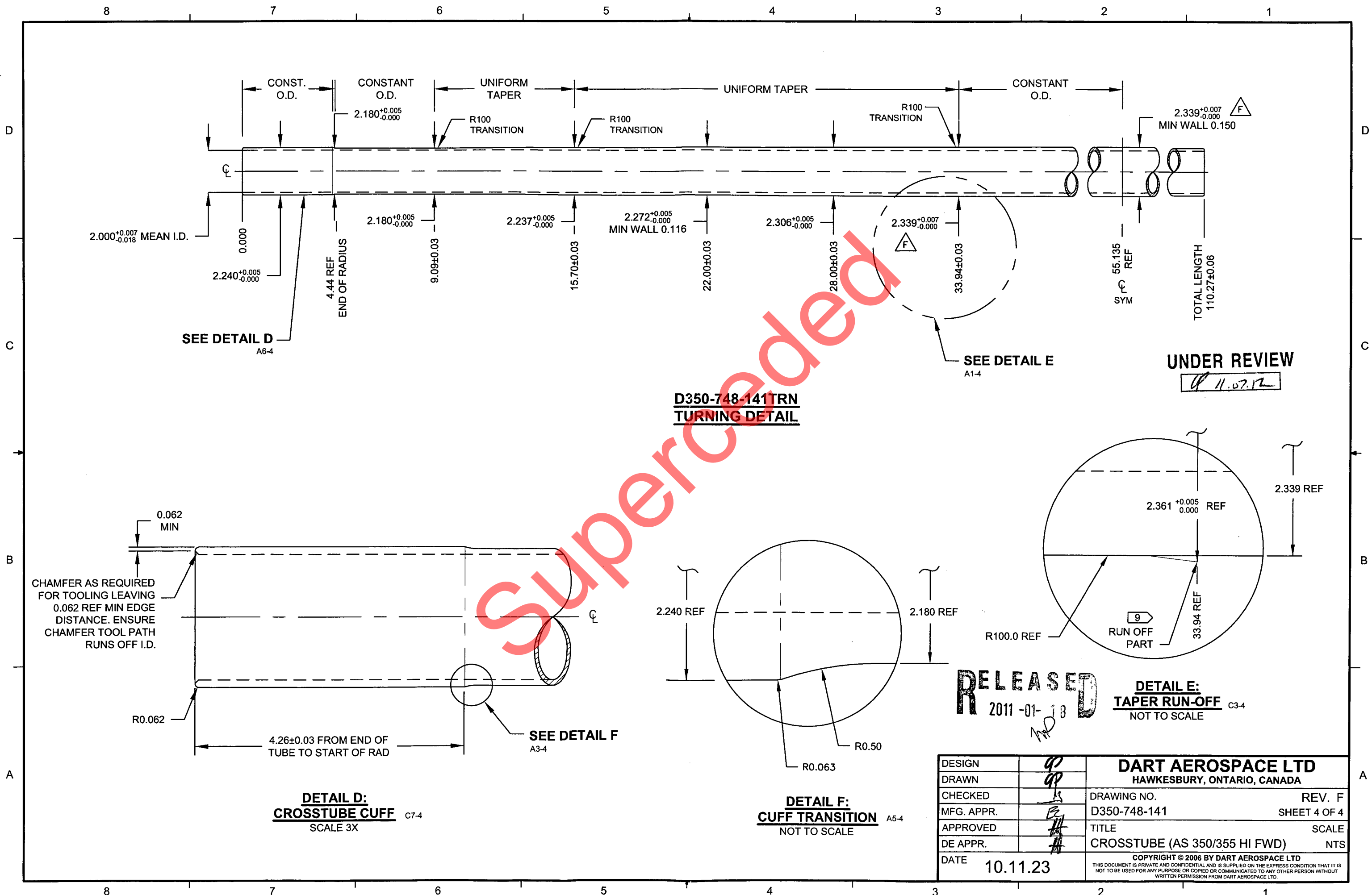
RELEASED
2011-01-18
MD



SECTION B-B D3-3
SCALE 4X

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	13	DRAWING NO.	REV. F
MFG. APPR.	2	D350-748-141	SHEET 3 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	CROSSTUBE (AS 350/355 HI FWD)	NTS
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8 7 6 5 4 3 2 1



UNDER REVIEW

11.07.12

D350-748-141TRN
TURNING DETAIL

DETAIL D:
CROSSTUBE CUFF C7-4
SCALE 3X

DETAIL F:
CUFF TRANSITION A5-4
NOT TO SCALE

DETAIL E:
TAPER RUN-OFF C3-4
NOT TO SCALE

RELEASED
2011-01-18

DESIGN	gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	gp		
CHECKED	js	DRAWING NO.	REV. F
MFG. APPR.	js	D350-748-141	SHEET 4 OF 4
APPROVED	js	TITLE	SCALE
DE APPR.	js	CROSSTUBE (AS 350/355 HI FWD)	NTS
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DRAWING NO. D350-748-141	TITLE CROSSTUBE (AS 350/355 HI FWD)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-141-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.04.02	DATE 12.04.03	DATE 12.04.03	DATE 12.04.03		DATE 12.04.03		

PURPOSE:

ADD A STRESS RELIEF OPERATION FOLLOWING BENDING

CHANGE:

ADD

10) AFTER BENDING: STRESS RELIEF AT 650°F ± 25°F FOR A MINIMUM OF 2 HRS.
AIR COOL TO AMBIENT TEMPERATURE
(REF. AMS2759/1E)

Superseded